

Date: Tuesday, 24/06/2008 3:42:37 PM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : PLUG
 Job Number : 40048
 Estimate Number : 10930
 P.O. Number :
 This Issue : 24/06/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : 1/1 Type : MACHINED PARTS
 Previous Run : 39826
 Part Number : D2057
 Drawing Number : D2057 REVC
 Project Number : N/A
 Drawing Revision : C
 Material :
 Due Date : 24/06/2008 Qty: 200 Um: 100 Each
 Written By :
 Checked & Approved By : JUP 08.6.24
 Comment : Est D 02.08.22 Make in Cobra - KJ
 Est Rev:E 08-05-27 as per ECN1195P DD verified by:EC
 Est Rev:F 08-06-04 Added QC8 JLM Verified By:EC
 Est Rev:G 08-06-20 rev.D as per dwg DD verified by:EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6R0750 6061-T6 Round Bar .750"



Comment: Qty.: 0.1050 f(s)/Unit Total : 10.5000 f(s)
 6061-T6 Round Bar .750"
 Material: 6061-T6 (QQ-A-225/8) Ø0.75 Rod
 (M6061T6R0.750) Batch M103857

J.F. 08/06/25 (203)

2.0 HARDINGE HARDINGE CNC LATHE SMALL



Comment: HARDINGE CNC LATHE SMALL
 Make as per Dwg D2057 and Folio FA260.
 Break all sharp edges 0.015 max.Do not drill Ø0.191

J.F. 08/06/25 (203)

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 08/06/25 (203)

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

RP 08/06/25 (203)

5.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
 Identify and Stock
 Location: 10

8/6/26

(203)
 SP

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 24/06/2008 3:42:37 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PLUG

Job Number: 40048

Part Number: D2057

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



08/07/01 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



JLD 08-6-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 40048
Description: Plug		Part Number: D2057
Inspection Dwg: D2057	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.15	+/-0.030	1.150"	✓			
0.15	+/-0.030	.149"	✓			
0.75	+/-0.030	.748"	✓			
0.030 x 45°	+/-0.010	.025"	✓			
0.438-0.425	N/A					
0.36	+/-0.030					
Ø0.191	+0.005/-0.001					
.397-.402	N/A	.399"	✓			

Measured by: J.F.	Audited by: J.L.	Prototype Approval:	N/A
Date: 08/06/25	Date: 08/06/25	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.02.17	New Issue	KJ/JLM	
B	07.11.26	Dimensions added	KJ/EC/DD	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8

7

6

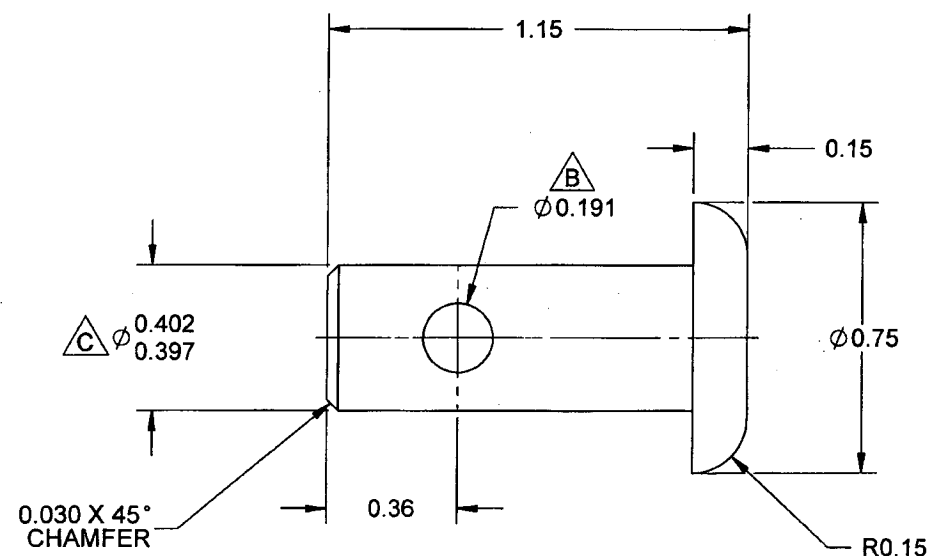
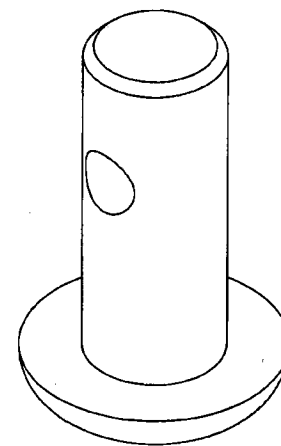
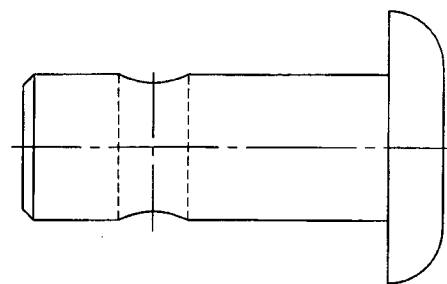
5

4

3

2

1



D2057 PLUG

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 40048

RELEASED
08-06-10

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ROUND BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF DART SPEC M6061T6R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.02 lbs

C	Ø 0.402/Ø 0.397 WAS Ø 0.430/Ø 0.425; REASON: ID OF D2010-103/-104 DECREASED TO Ø 0.402	PH	08.06.10
B	REDRAWN; Ø 0.191 WAS Ø 0.187 (TSR A1100)	CP	98.10.15
A	NEW ISSUE	JB	92.03.13
REV.	DESCRIPTION	BY	DATE
DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JB		
CHECKED	JB	DRAWING NO.	REV. C
MFG. APPR.	JB	D2057	SHEET 1 OF 1
APPROVED	JB	TITLE	SCALE
DE APPR.	JB	PLUG	NTS
DATE	08.06.10	COPYRIGHT © 1992 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	